

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016507**Date Inspected:** 19-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhu Feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

**TOWER JETTY**

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 4A located on North tower Lift-3 cross bracing gusset plate to skin'E' WD – GUSA3 – 3 – 109M – N.

Welder is identified as 040365. ZPMC Quality Control (QC) Inspector is identifiedFu Wei Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2212 – Tc – U5 – FCM. (See attached photo)

Weld joint # 4A located on South tower Lift-3 cross bracing gusset plate to skin'E' WD – GUSA3 – 3 – 109M – S.

Welder is identified as 052910. ZPMC Quality Control (QC) Inspector is identifiedFu Wei Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2212 – Tc – U5 – FCM.

**BAY#10**

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

Weld joint # 35 located on North tower Lift-5 Grillage Assembly NSD1 – TL5 – 3B/F. Welder is identified as 066422. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – TC – U4c.

Weld joint # 7B located on South tower Lift-5 Grillage Assembly SSD1 – TL5 – 1B/F. Welder is identified as 052930. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – TC – U5b.

BAY#11

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 2A located on East tower Lift-5 Grillage Assembly ESD1 – TL5 – 2B/F. Welder is identified as 046769. ZPMC Quality Control (QC) Inspector is identified as Ma Qian Li. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – TC – U5b.

Weld joint # 3A located on Lift-5 Splice Plate Stiffener WSD1 – SPSA5 – 17. Welder is identified as 202100. ZPMC Quality Control (QC) Inspector is identified as Liu Dao Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3211 – Tc – U5b – 1.

Weld joint # 19 located on West tower Lift-5 Grillage Assembly WSD1 – TL5 – 4B/F. Welder is identified as 067993. ZPMC Quality Control (QC) Inspector is identified as Ma Qian Li. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – TC – U4c.  
(See attached photo)

Weld joint # 30 located on West tower Lift-5 Grillage Assembly WSD1 – TL5 – 4E/F. Welder is identified as 067611. ZPMC Quality Control (QC) Inspector is identified as Ma Qian Li. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3313 – TC – P5.

Heat Straightening:

Heat Straightening being performed on Tower Lift-5 splice plate stiffener identified as WSD1-SPSA5-20 by oxy-acetylene flame method to remove the distortion that occurred after welding. ZPMC Quality Control (QC) Inspector is identified as Liu Dao Feng present at the location. This activity appeared to comply with the Heat Straightening Report # HSR1 (T) – 11471.

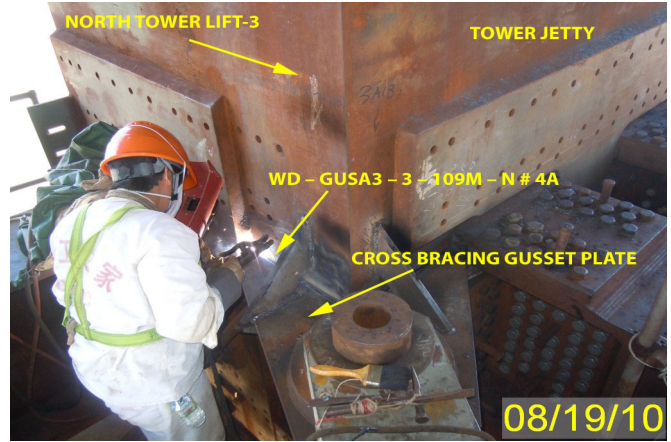
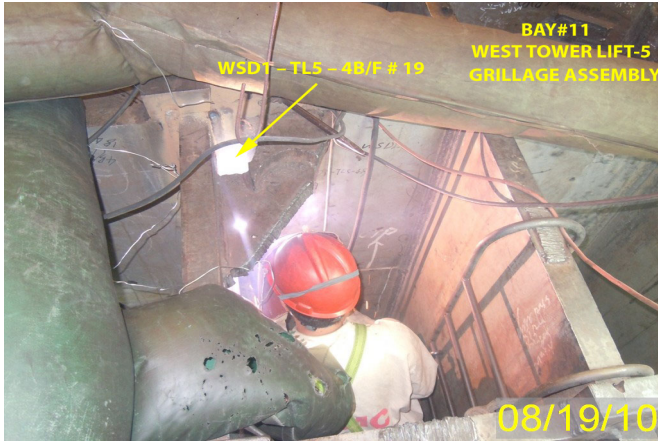
Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---



## Summary of Conversations:

No Relevant Conversations.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Michael Ng - 15921845703, who represents the Office of Structural Materials for your project.

---

**Inspected By:** Kumar,Sandeep

Quality Assurance Inspector

---

**Reviewed By:** Clifford,William

QA Reviewer